Work Ord Wednesday, Aug							,			,	Page 1
Item ID: Revision ID:	D3490-3			Accept				s	etup Stai	·t	
Item Name:	Cross Bolt Spa	acer							Sto	Р	
Start Date: Required Date: Reference:	8/31/2011 : 9/15/2011	Start Qty: 60.00 Req'd Qty: 60.00		8 1 1 1 1 1 1 1 1 1	Cust Item I Customer:	D:					
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:		F	Run Star Sto		
	QC:		Date:	SPC (Y/N):	D	ate:			3.0		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3490	Rev	, A									
Hardinge CNC Latt	he Small	DWG REV	S PER FOLIO FA6.	0.00 0.00 29 & DWG D3490	11/09/23		. •	60	ø		· <u></u>
QC Quality Control		QC2- Inspect parts off a Memo		0.00 0.00 ml 10	01/23			60	<i>)</i> 8″	- · <u>-</u> ·	· · · · · · · · · · · · · · · · · · ·
120 QC Quality Control	,	QC8- Inspect parts - se	cond check	0.00 0.00 B.	1 11 09 23			60	\$		

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W/O:		(A) A (A) (A) (A) (A) (A) (A) (A) (A) (A	W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•							
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	on:	QA: N/C C	osed:		Date: _	
NCR:		V	ORK ORD	ER NON-CONFORMAN	NCE (NCF	?)			
DATE	STEP	Description of NC	of NC Corrective Action Section			Verific	ation	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector
				,					
		·		. ,					
		· .							
						,			

Work Order ID 73295

Wednesday, August 31, 2011 10:44:07 AM



Page 2

Item ID:

D3490-3

Accept

Setup Start

Stop



Revision ID:

Start Date:

Cross Bolt Spacer Item Name:

8/31/2011

Start Qty: 60.00

Req'd Qty: 60.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Tool ID

Start Run

Reject

Oty



Required Date: 9/15/2011

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Insp.

Stamp

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: C;

STOCK IN SKIDTUBE CELL

Set Up/ Run Hours

0.00

0.00

Accept

Qty

Number

Reject

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

Memo

0.00

MY 19/2/ 1/9-93

		— - - -								
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	B	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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										L
Part No	•	PAR #:	Fault Cat	egory:	_ NCR: Y	es N	o DQ	\ :	_ Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/	C Clos	sed:		Date: _	
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (N	ICR)				
DATE	STEP	Description of NC	Description of NC Corrective Action				Verific	ation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		gn & late	Section		Chief Eng	QC Inspector
								!		

Picklist Print

Wednesday, August 31, 2011 10:44:04 AM

Work Order ID: 73295

Parent Item:

D3490-3

Parent Item Name: Cross Bolt Spacer



Start Date: 8/31/2011

Required Date: 9/15/2011

Page 1

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	32.5530	0.266	16.8			

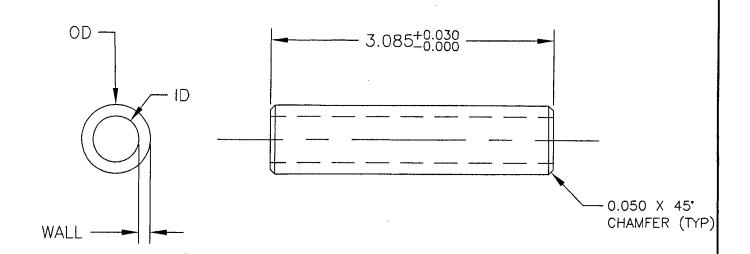
6061-T6 Round Bar .750"

Location		Loc Qty	Loc Code		
MAT013		32.553			
1	12442	0.796			-
1	16406	0.617			•
1	17481	12.76		10'	$\sim 0 / 1$
- ₹7 1	18106	18.38	•	_6.8	CM/1/09/23

Duit Aci	oopaoo								
W/O:			WC	RK ORDER CHANG	SES				•
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	n:	QA: N/C Clo	osed:		Date: _	
NCR:		V	VORK ORD	ER NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC			tion B		cation	Approval	Approval
	JIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
								,	
	:								
					:				



DESIGN	PH	DRAWN BY	DART	AEROSPACE USA	, INC.
CHECK	ED #	APPROVED 4	drawing no. D3490	S	REV. A
DATE			TITLE		SCALE
06.0	1.04		CROSS BO	OLT SPACER	NTS
A		06.01.04	NEW ISSU	JF	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490=3=3	-0.750 <	5 0.080	₹ 0.591 *	=M6061T6R0.750=
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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Dail AQ	Johado								
W/O:			WC	ORK ORDER CHAI	NGES				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate		NCR: Ye	es No	DQA:	Date: _	1
	R	esolution:	Dispositio	n:	QA: N/C	Closed:		Date: _	
NCR:		V	WORK ORDI	ER NON-CONFOR	MANCE (N	CR)			
DATE	STEP	Description of NC	on of NC Corrective Action		Section B		erification	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		ate	Section C	Chief Eng	QC Inspector
	i								

DART AEROSPACE LTD	Work Order:	
Description: Crossbolt Spacer	Part Number:	D3490-3
Inspection Dwg: D3490 Rev: A		Page 1 of 1

	FIRS	T ARTICLE IN	NSPECTI	ON CHE	ECKLIST		
	2	X First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
3.085	+0.030/-0.000	3.115			871-7		
0.080	+/-0.010	077			•		
Ø0.591	+0.008/-0.001	0.597					
0.050 x 45°	+/-0.010 x 0.5°	24 4020					
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Measured by:	(1912)	Audited by:	A.C.		Prototype Ap		N/A
Date:	IU Vdd	Date:	11/09/23	<u> </u>		Date:	N/A
Rev Date	Change				Re	vised by	Approve⁄d
A 06.10.27	New Issue				KJ	/JLM 🚓	1/11/

Dart Ae	rospace	e Ltd							
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	:	Date:	
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		Description of NC		Corrective Action Section	n B	Verifica	etion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
		. •							
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